

Date: Friday, 17/08/2007 11:21:37 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER PLATE, LH
Job Number	: 34093		
Estimate Number	: 12221		
P.O. Number	: N/A	Part Number	: D34671
This Issue	: 17/08/2007 S.O. No. : N/A	Drawing Number	: D3467 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 26861	Material	: N/A
Written By	: <u>07.08.20</u>	Due Date	: 11/09/2007
Checked & Approved By	: <u>07.08.20</u>	Qty:	10 Um: Each
Comment	: est rev. A 06.04.20 new issue EC Est Rev:B As per Rev B 06-05-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.7718 sf(s)/Unit Total : 7.7175 sf(s)  
 304/316 0.018 SHEET batch: ~~M105445~~ M105490 07-09-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 Cut as per Dwg D3467  
 Dwg Rev: B  
 Prog Rev: B

B 07-09-11

(10)

P70



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-09-11

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07-09-11

(10) county

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Debur

2-Form as per dwg D3467

MF 07-10-23 (10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.09.04	2.0	REPLACE SCRAPPED ITEMS. NOTE: DXF FILE SUPPLIED IS BASED ON CURRENT ORIGINAL REVISION (SEE ATTACHED) DRAW WITH HATCH CHANGES). CHANGE QUANTITY OF PERALINK QTY. (2) Ø0.250" HOLES WITH Ø0.250" x 0.500 SLOTS.				07.09.04	07.09.04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 07/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.04	2.0	Ø0.250" HOLE LOCATED @ (x,y) COORDINATES (5.875, 7.700) WAS LOCATED @ (5.875, 7.700). 10 PARTS SCRAP		SCRAP & REPLACE	07-09-11 HB SAD 07/09/11	07/09/11	07.09.04	07.09.04
		PC WAS THE DXF WAS WRONG						

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:37 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE, LH

Job Number: 34093

Part Number: D34671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/5 07/10/23

POSITIVE  
10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-23

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10

Job Completion



U 07.10.23 12/11/23  
POSITIVE RECALL  
EFFECTIVE 07-10-23 AUTH  
RELEASED DATE

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

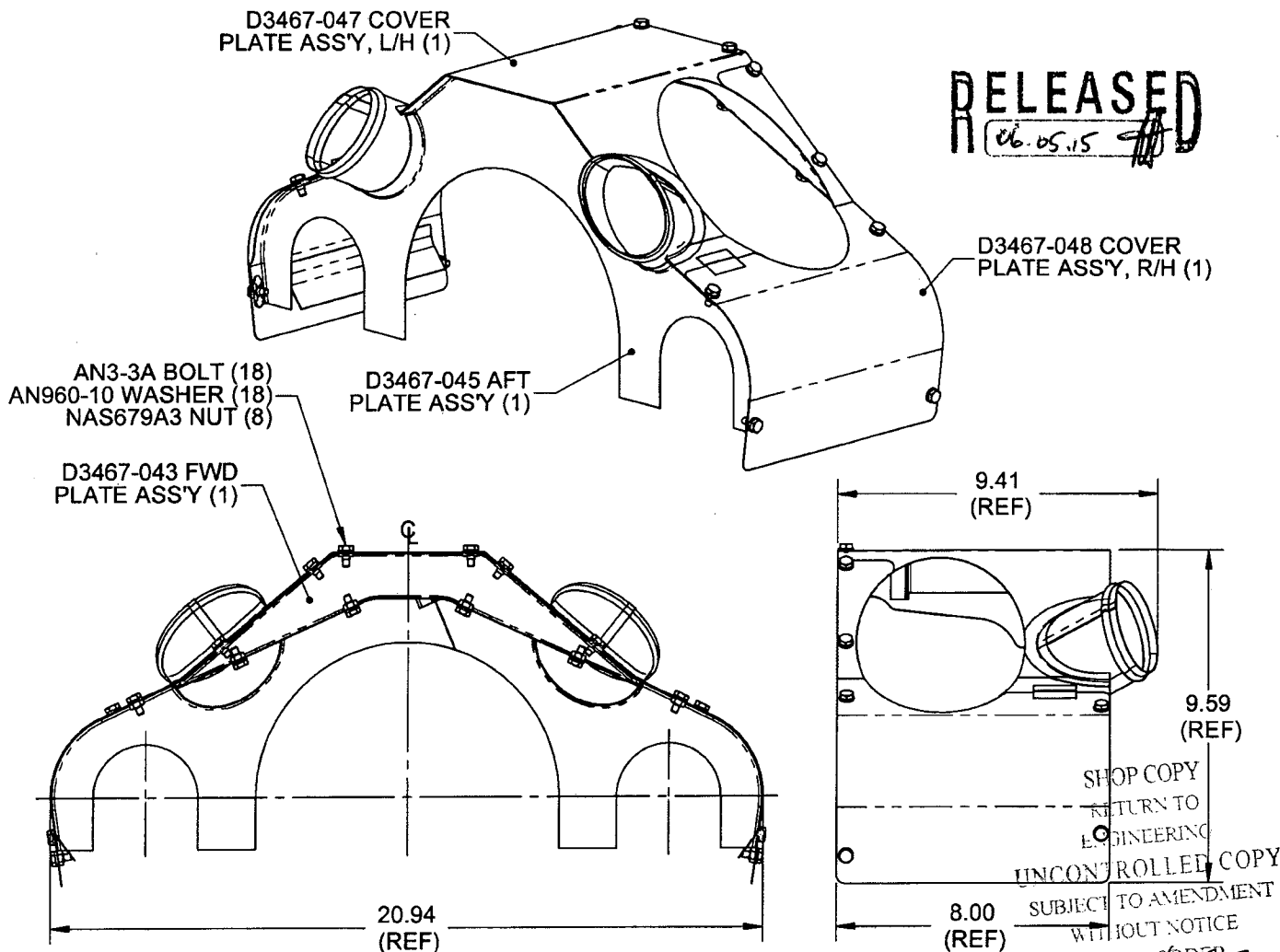
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

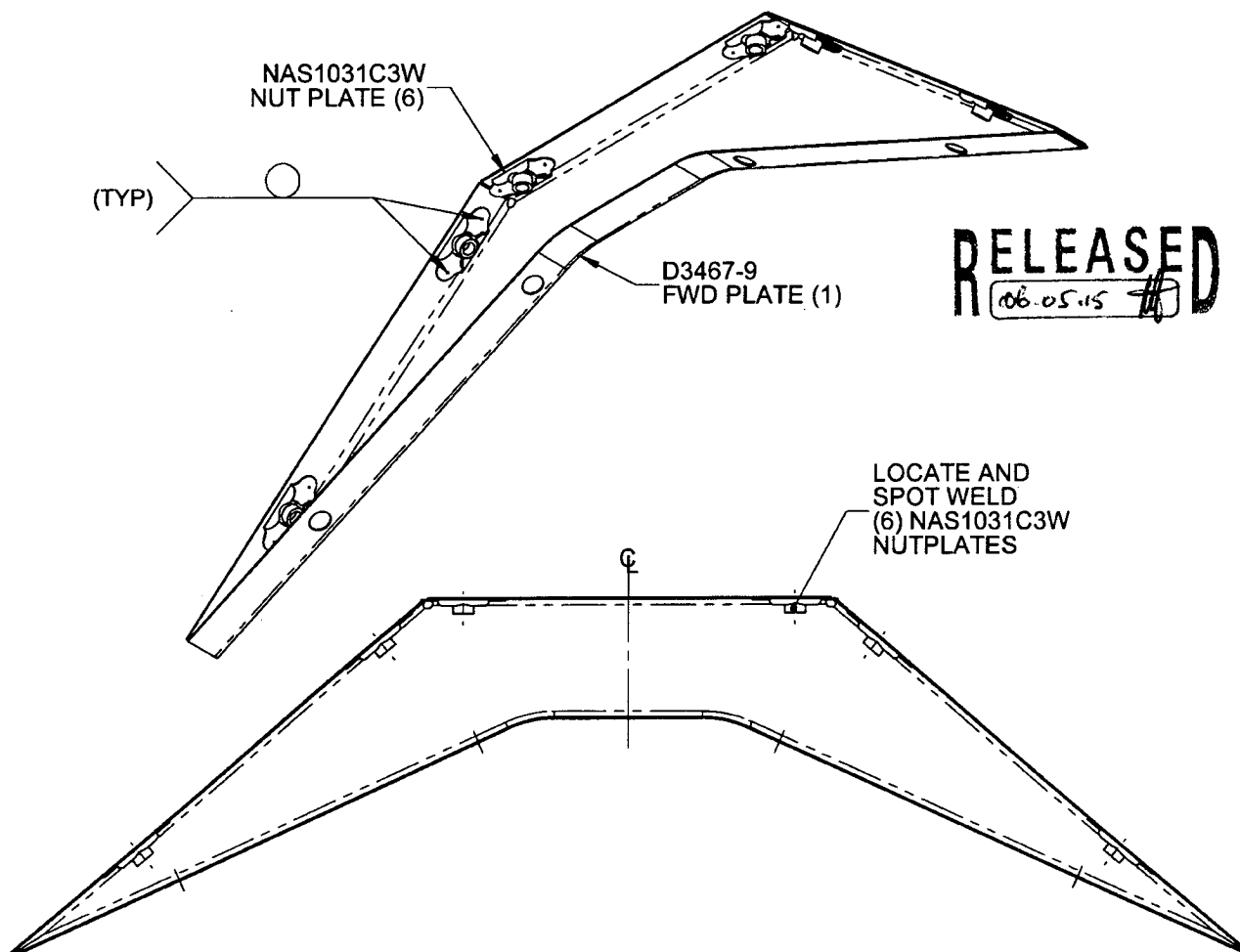
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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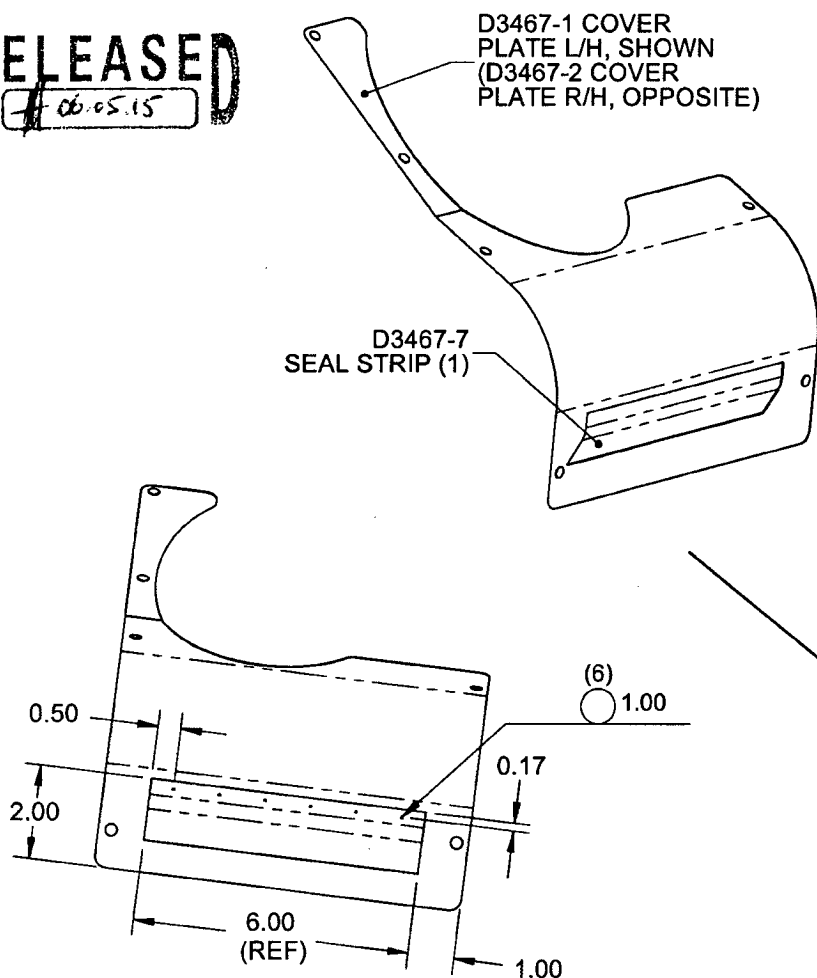
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**RELEASED**  
#06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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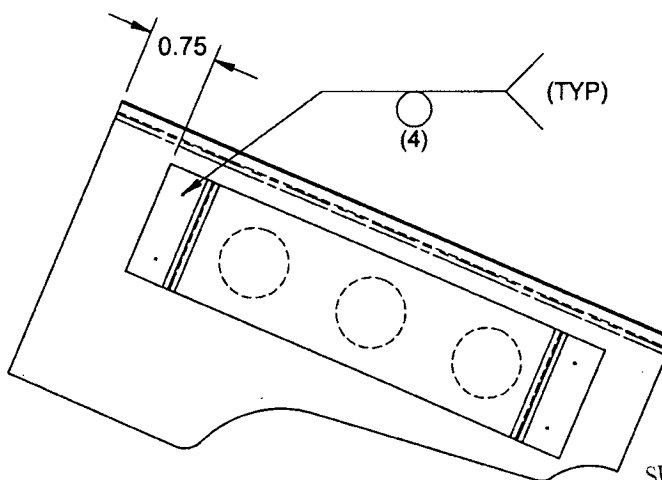
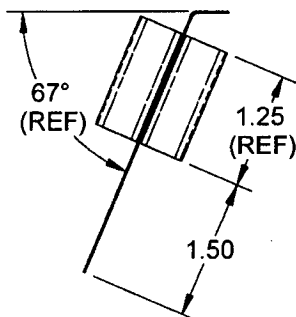
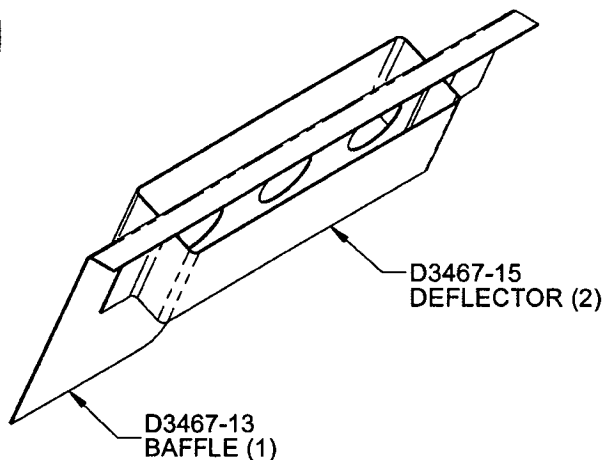
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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06.05.15



### D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

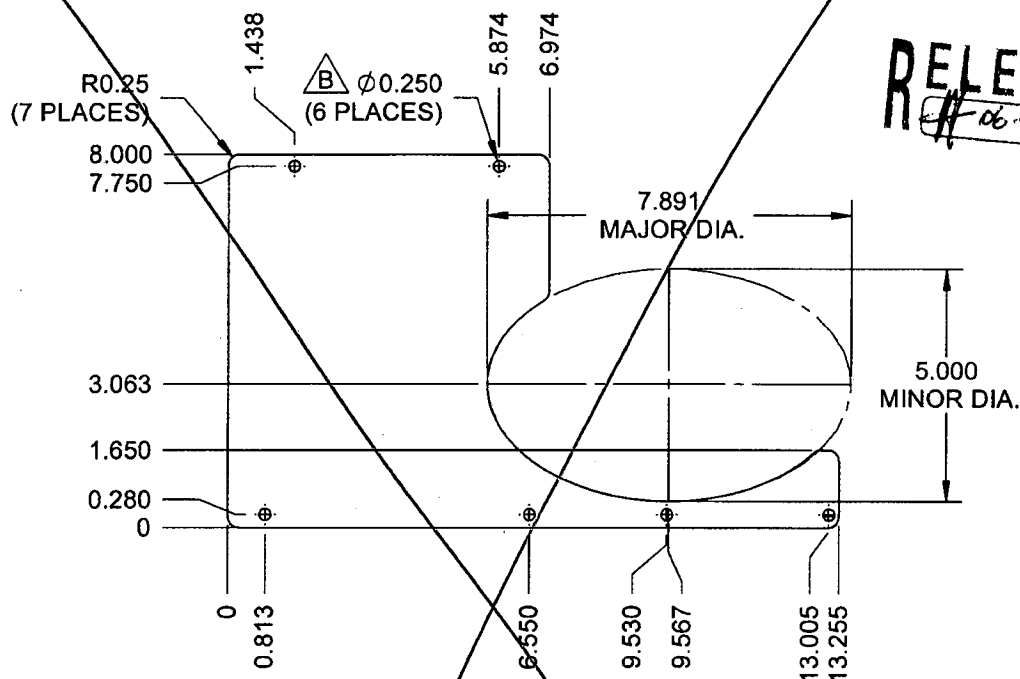
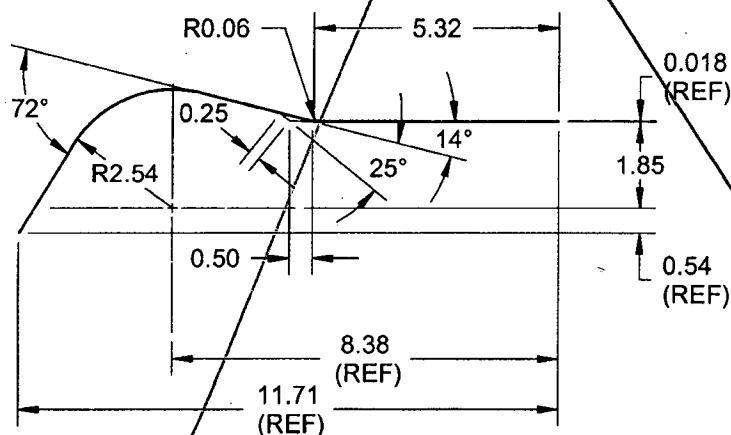
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER  
PLATE ISOMETRIC VIEW.  
D3467-2 R/H COVER  
PLATE (OPPOSITE)**

SCALE 1:8

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**NOTES:**

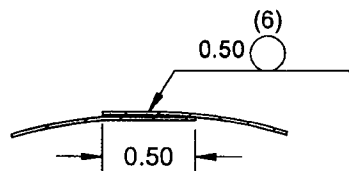
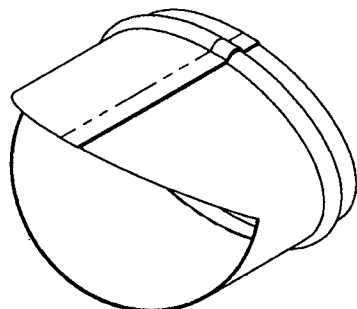
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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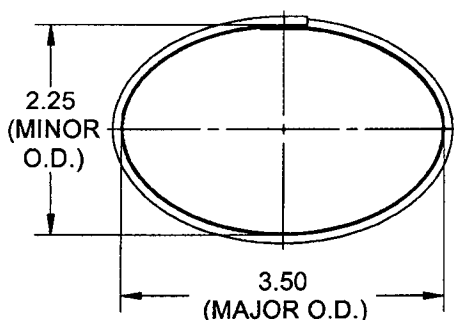
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

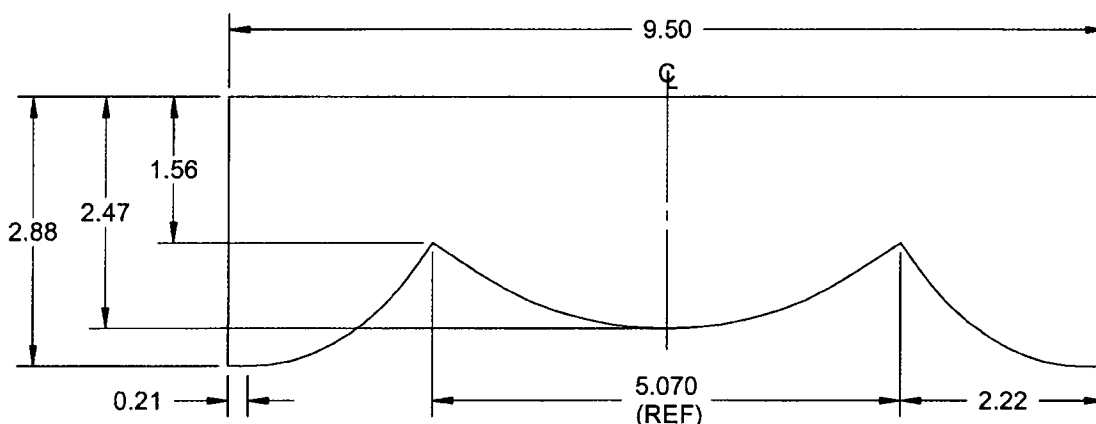
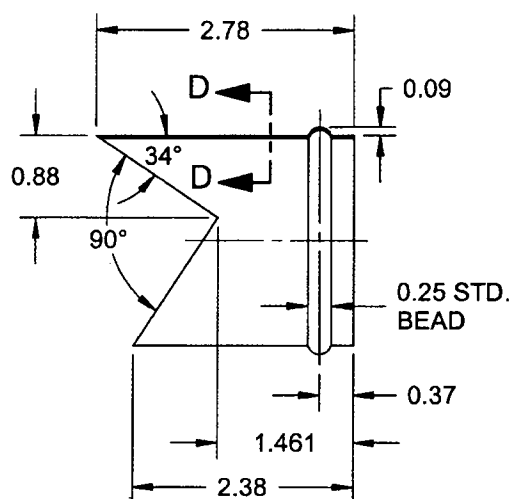
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# 06.05.15



**SECTION D-D**  
**SCALE 1:1**



### **D3467-3 TUBE DETAIL**



## D3467-3F TUBE FLAT PATTERN

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

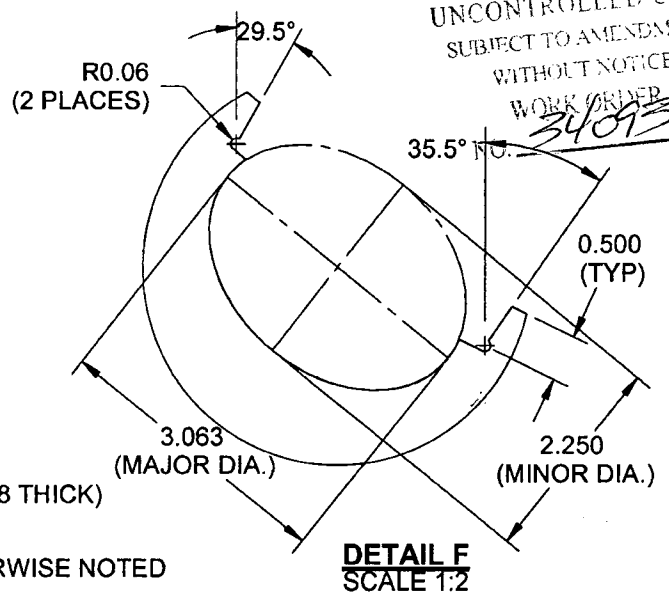
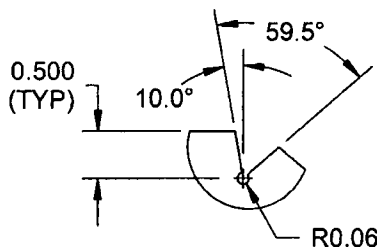
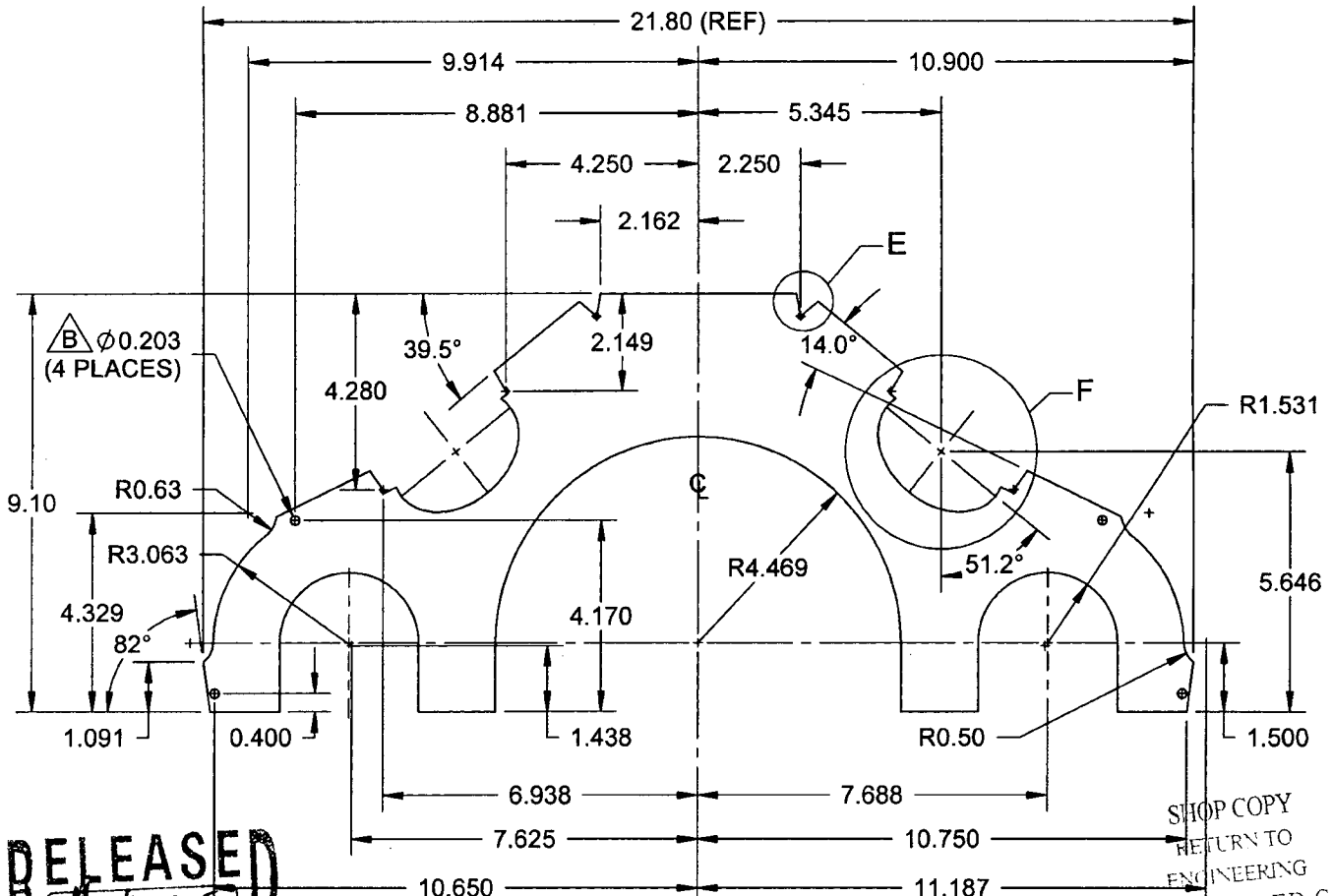
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 8 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



### D3467-5F AFT PLATE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

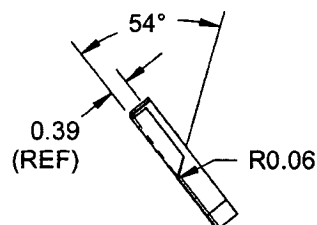
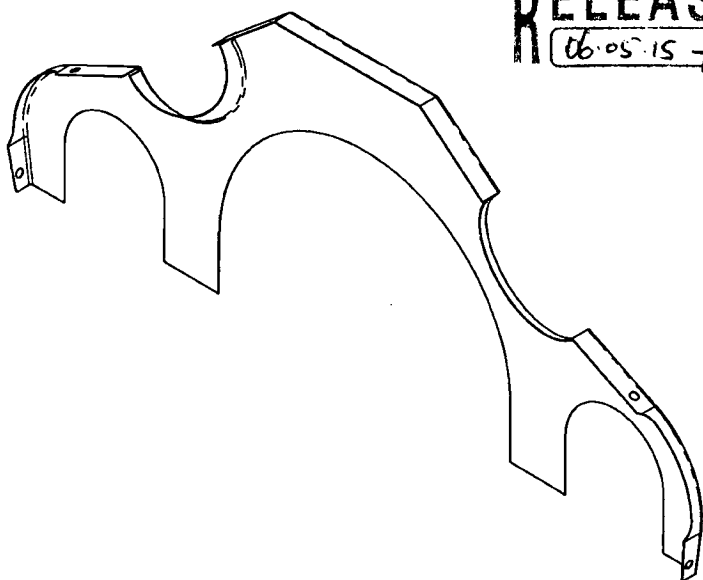
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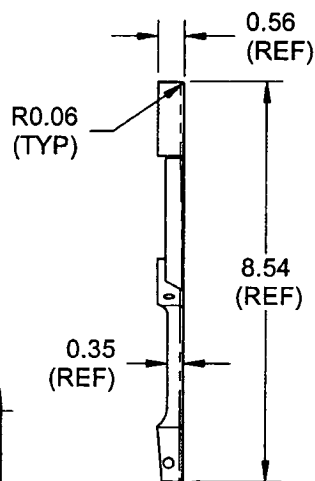
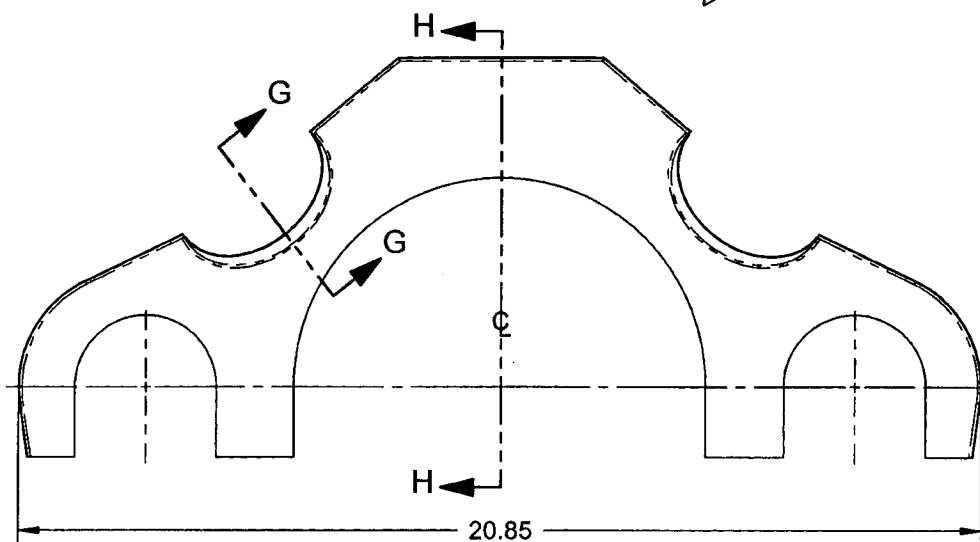


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED  
06.05.15



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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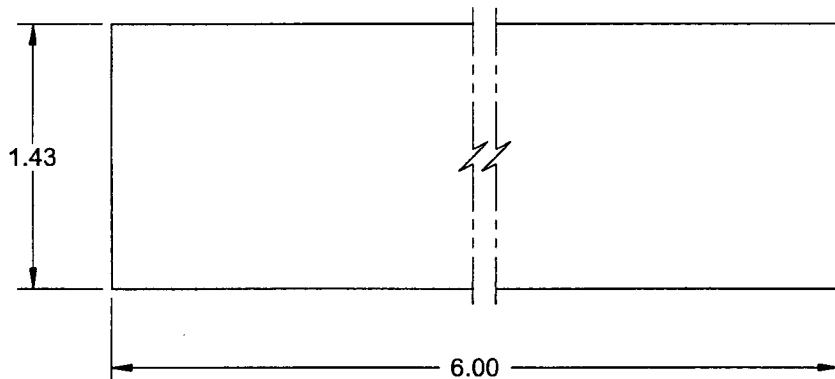
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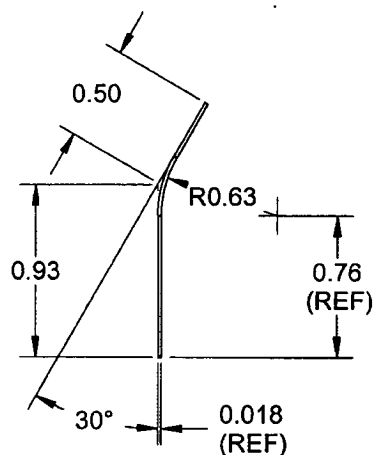


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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3467	REV. B SHEET 10 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

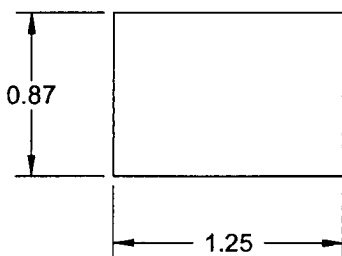
RELEASED  
06.05.15 *#*



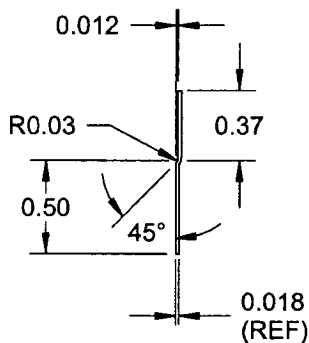
**D3467-7F SEAL STRIP  
FLAT PATTERN**



**D3467-7 SEAL STRIP  
BENDING DETAIL**



**D3467-11F BRACKET  
FLAT PATTERN**



**D3467-11 BRACKET  
JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

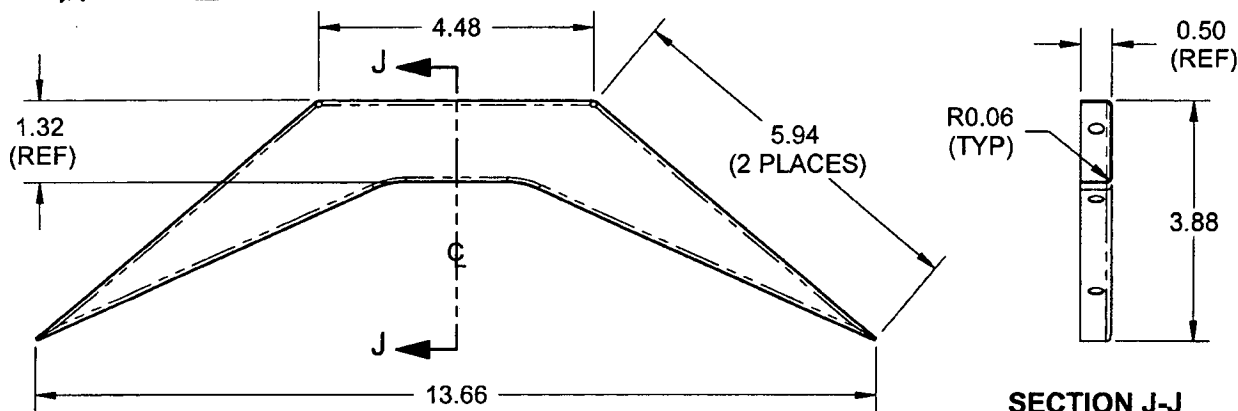
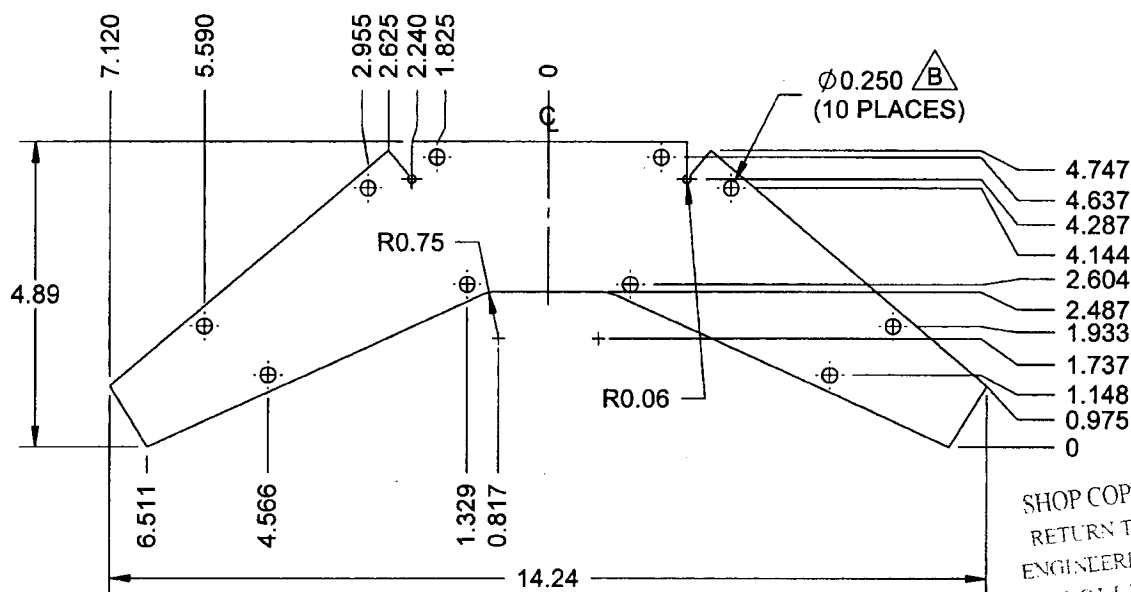
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 11 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:3

**RELEASED**  
*06.05.15***D3467-9 FWD PLATE BENDING DETAIL****D3467-9F FWD PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. *34093*

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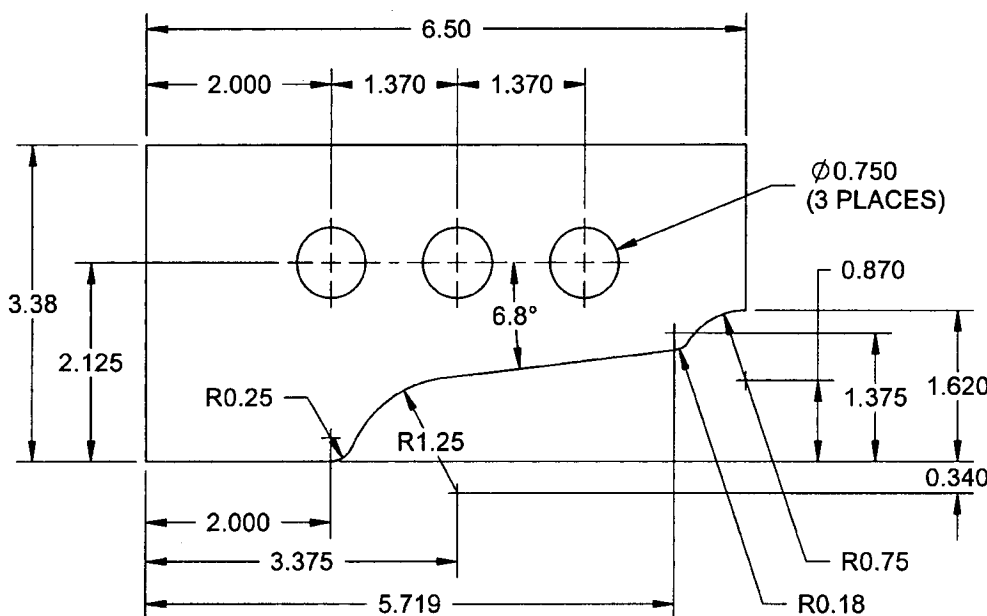
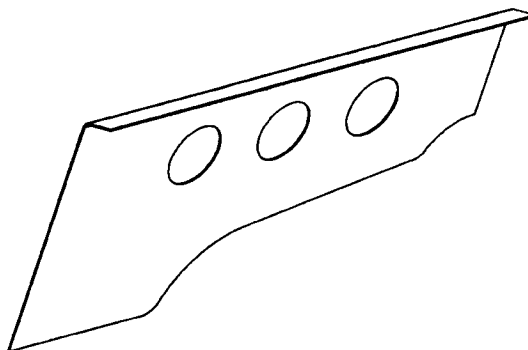
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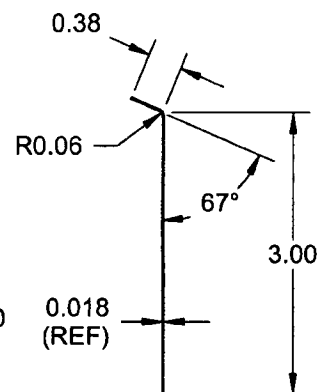


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 12 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

RELEASED  
*[Signature]* 06.05.15



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **34693**

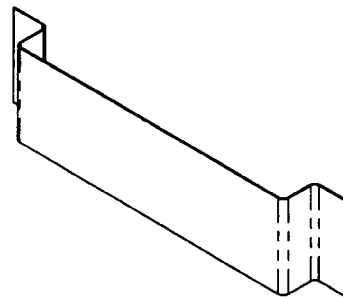
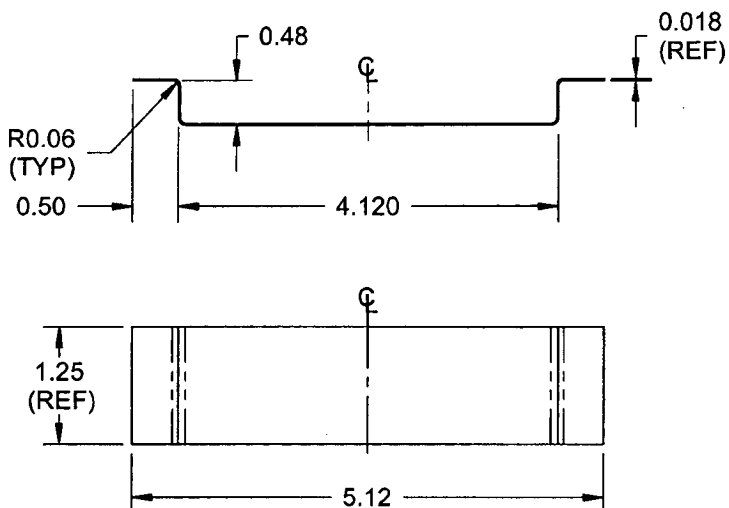
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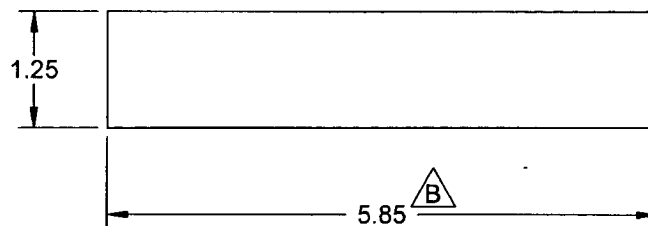


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CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3467	REV. B SHEET 13 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED  
*06.05.15*



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

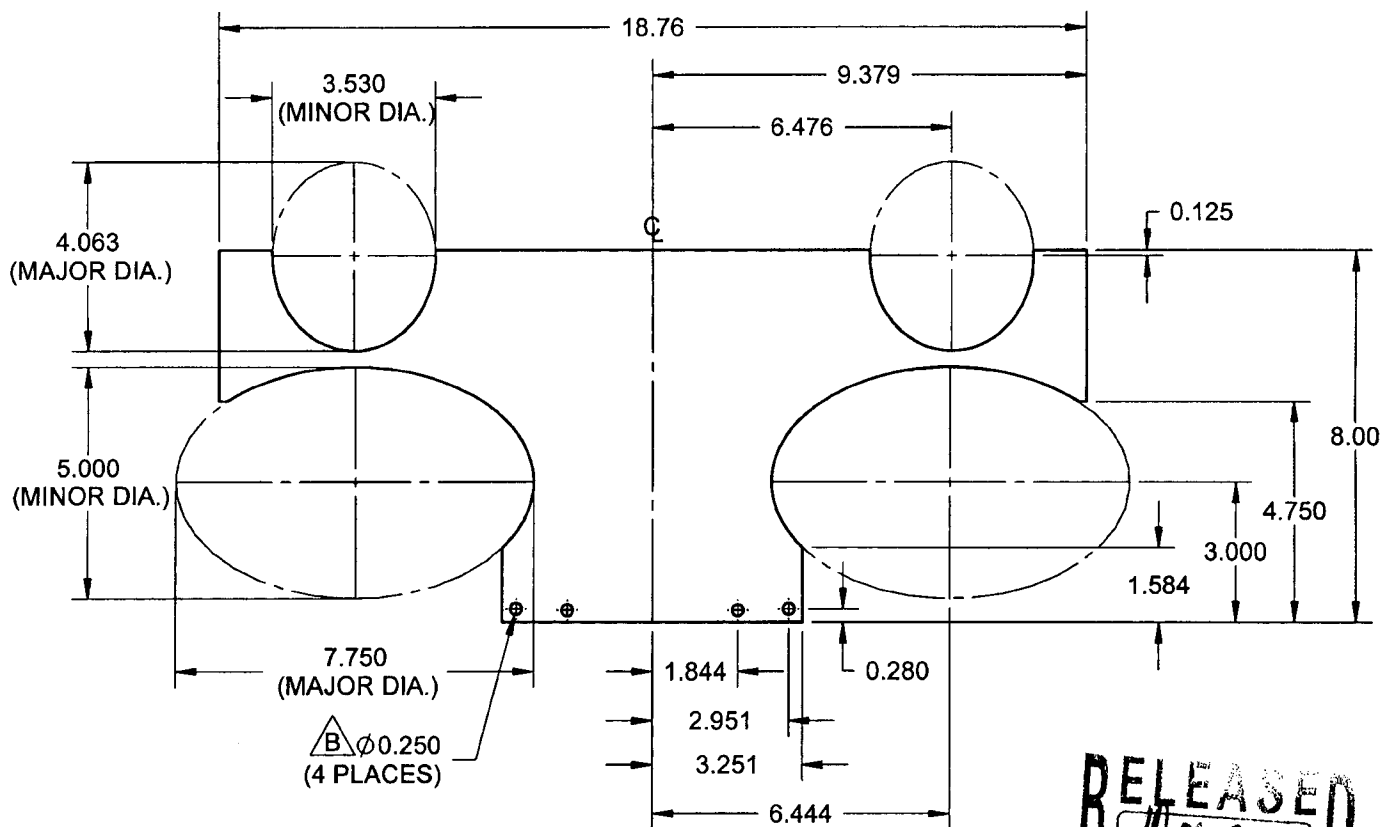
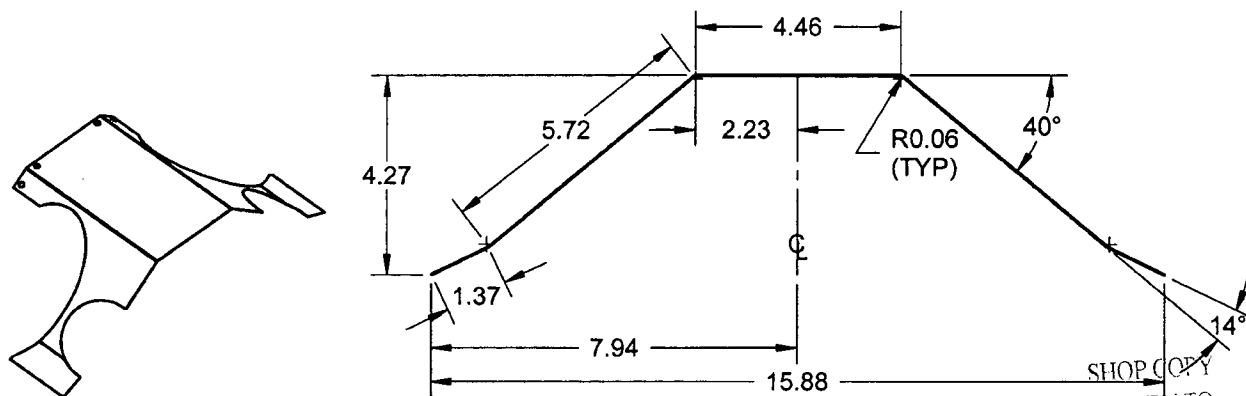
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**DART**

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CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 14 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**D3467-17F TOP COVER FLAT PATTERN****RELEASED**  
#06-05-15**D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **34093**

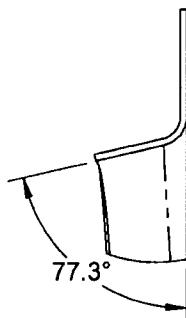
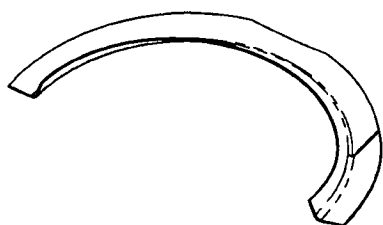
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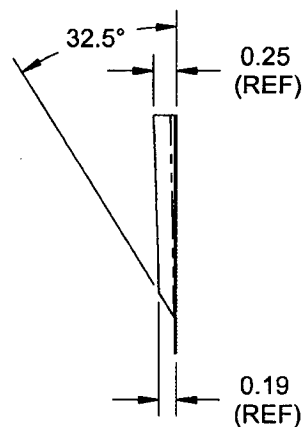
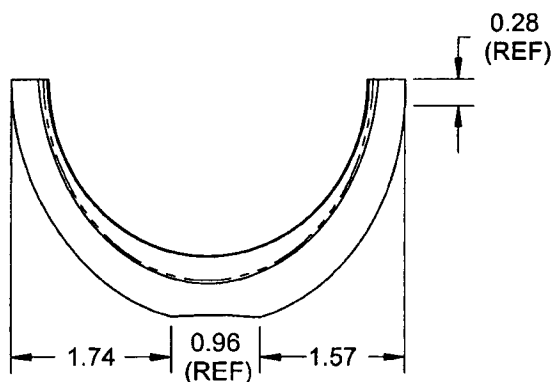
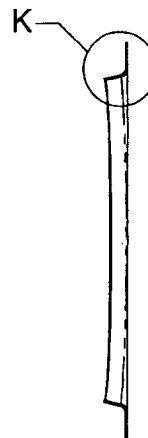


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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

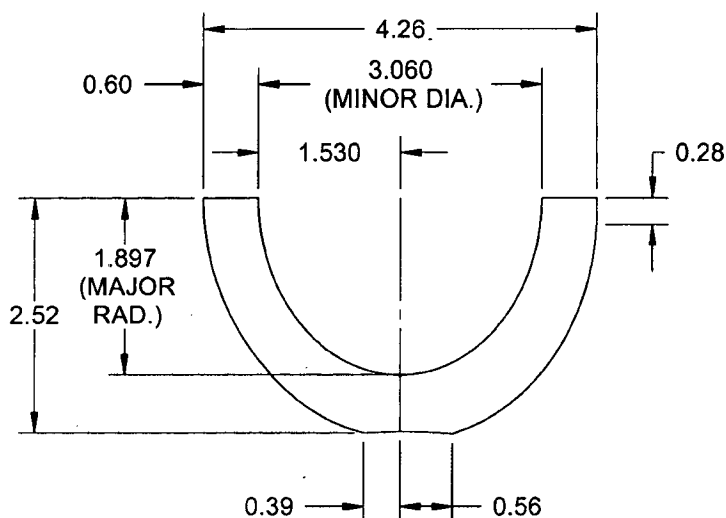
RELEASED  
*06.05.15*



**DETAIL K**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



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**D3467-19F FLAT PATTERN**  
WORK ORDER NO. *34093*

**NOTES:**

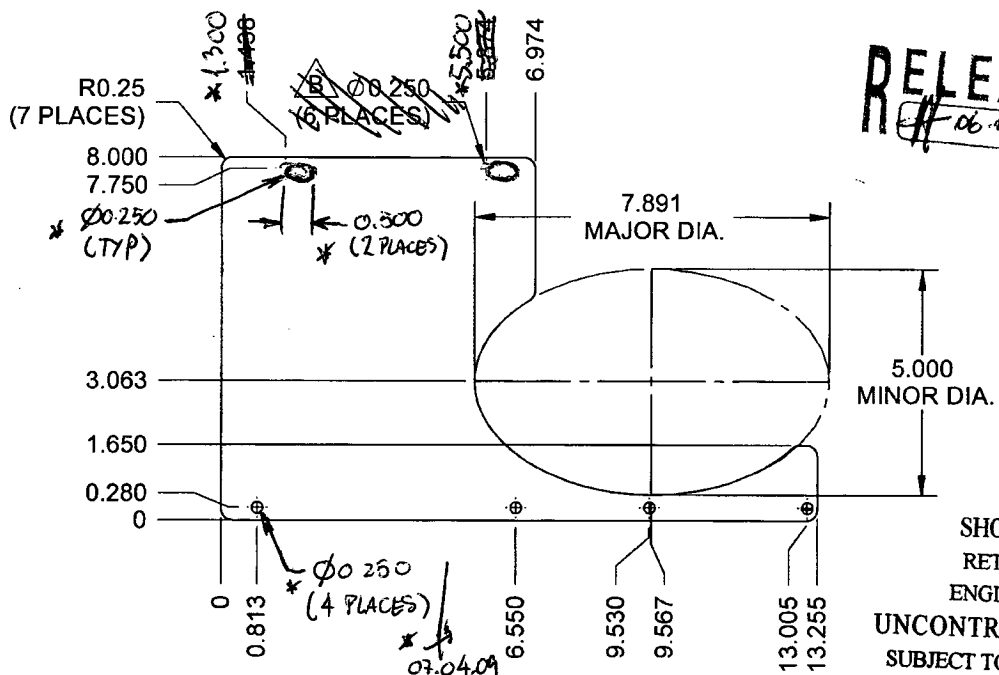
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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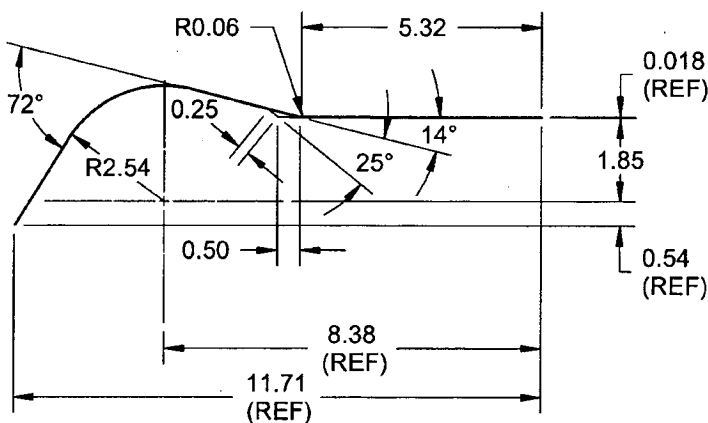
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 6 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

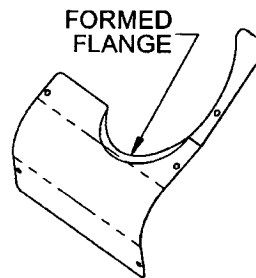


**D3467-1F COVER PLATE FLAT PATTERN**

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**D3467-1 L/H COVER PLATE**  
**D3467-2 R/H COVER PLATE (OPPOSITE)**



**D3467-1 L/H COVER PLATE ISOMETRIC VIEW,**  
**D3467-2 R/H COVER PLATE (OPPOSITE)**  
SCALE 1:8

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	34093
Description: COVER PLATE LH		Part Number:	D3467-1
Inspection Dwg: D3467 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .750X.500	+ .005 - .001	.754 X .503	X			
Ø .750	+ .005 - .001	.754	X			
.813	+/- .010	.813	X			
6.550	+/- .010	6.550	X			
9.530	+/- .010	9.530	X			
<del>13.005</del>	+/- .010	13.005	X			
13.005	+/- .010	13.005	X			
13.255	+/- .010	13.255	X			
.280	+/- .010	.280	X			
1.650	+/- .010	1.650	X			
7.750	+/- .010	7.750	X			
8.000	+/- .010	8.000	X			
1.300	+/- .010	1.300	X			
5.500	+/- .010	5.500	X			
6.914	+/- .010	6.915	X			
1018	+/- .010	1019	X			

Measured by: <b>FB</b>	Audited by: <b>En</b>	Prototype Approval: <b>HA</b>
Date: <b>07-09-11</b>	Date: <b>07/09/11</b>	Date: <b> </b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

